

Date: Monday, 27/10/2008 2:16:25 PM
 User: Julie Dawson

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : LEG |
| Job Number : 42981 | |
| Estimate Number : 13474 | |
| P.O. Number : | Part Number : D37733 |
| This Issue : 27/10/2008 S.O. No. : | Drawing Number : D3773 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : MACHINED PARTS | Drawing Revision : B |
| Previous Run : 40997 | Material : |
| Written By : | Due Date : 07/11/2008 Qty: 22 Um: Each |
| Checked & Approved By : <u>JUD 08.10.28</u> | |
| Comment : Est Rev:A New Issue 08-07-18 DD Verified By:ec | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR1000W065 | 304 RD Tube 1.00 x .065W |
|-----|----------------|--------------------------|



Comment: Qty.: 1.0500 f(s)/Unit Total : 23.1000 f(s)
 304 RD Tube 1.00 x .065W
 batch: M110010

JP 08/12/27

| | | |
|-----|--------------|--------------|
| 2.0 | DOOSAN LATHE | DOOSAN LATHE |
|-----|--------------|--------------|



Comment: Doosan Lathe

1- Turn as per Folio FA763 Rev: n/a & Dwg D3773 Rev: B

2-Deburr per dwg D3773

JP 08/12/27

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JP 08/12/27 (23)

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

J.F. 08/12/29 (23)

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 246

JP 08/12/30 (23)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3773-3 PAR #: N/A Fault Category: Prod/Machined Part NCR: (Yes) No DQA: D Date: 09/01/06
D3773-04 D3782-045 D412-789-043/044
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/01/06

| NCR: <u>42981</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|-----------|---|-----------------------------|--|---------------------------------------|---------------------------------------|---------------------------------------|---------------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| <u>08/12/07</u> | <u>20</u> | <u>1201 holes drilled 257. Tool # error in program. Operator error. at when choosing tool in machine. R.C. operator error.</u> | <u>[Signature]</u> | <u>Scrap & replace Qty 6 M110010</u> | <u>[Signature]</u> <u>08/12/07</u> | <u>[Signature]</u> <u>09-01-06</u> | <u>[Signature]</u> <u>09-01-06</u> | <u>[Signature]</u> <u>09-01-06</u> |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 27/10/2008 2:16:25 PM
User: - Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEG

Job Number: 42981

Part Number: D37733

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



23

Comment: FINAL INSPECTION/W/O RELEASE

20/01/06

Job Completion



MF 08-12-31

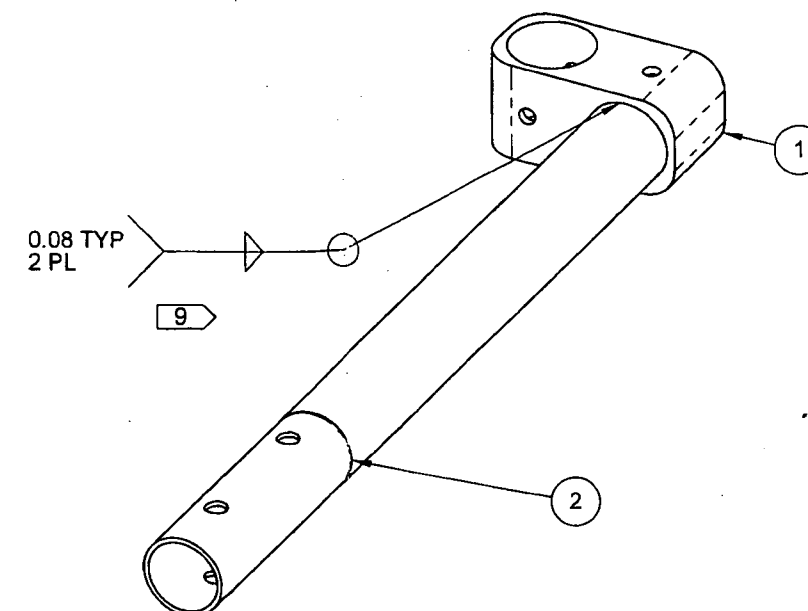
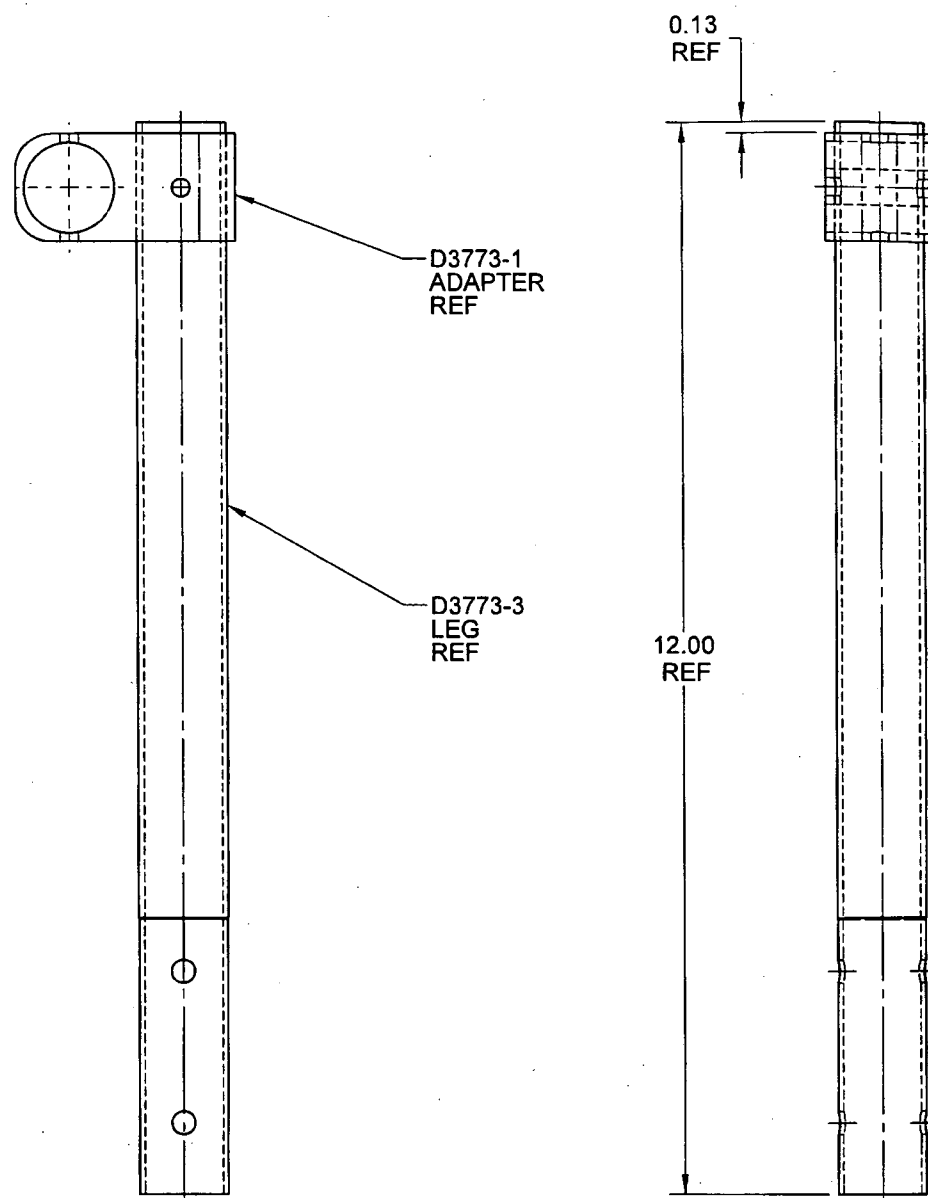
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. |
|----------|-------------|-------------|------|
| 1 | D3773-1 | ADAPTER | 1 |
| 2 | D3773-3 | LEG | 1 |

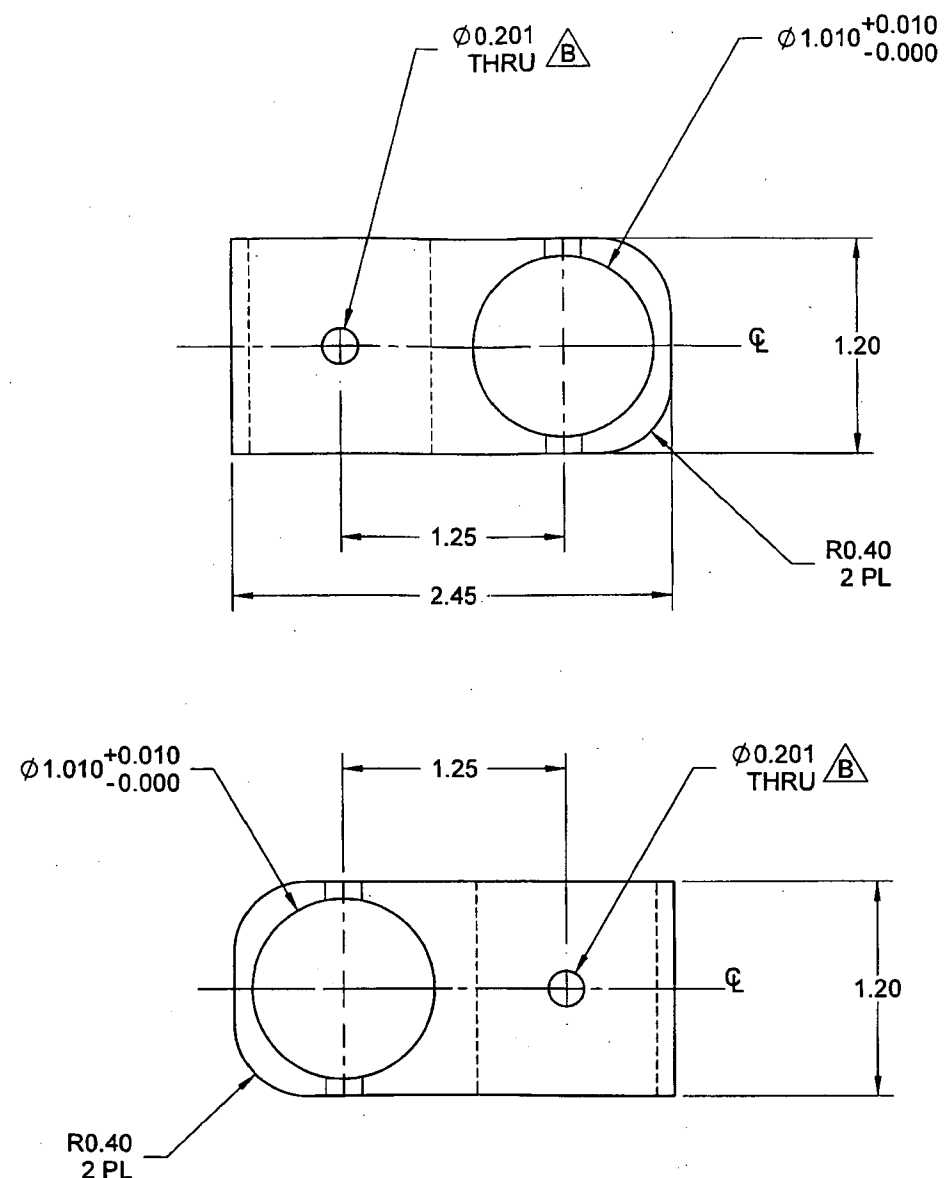
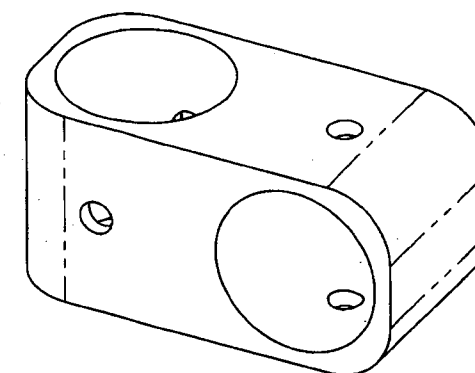
NOTES:

- 1) MATERIAL: SEE D3773-1/-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3773-1, 0.40 lbs
D3773-3, 0.69 lbs
D3773-041, 1.04 lbs
- 8) WELD: PER DART QSI 004
- 9) IF NECESSARY GRIND INTERIOR OF D3773-3 LEG FLUSH AFTER WELDING

D3773-041 HEADREST ASSEMBLY

| | | | |
|------------|---------------------------|---|--------------|
| B | CHANGE HOLE SIZE TO 0.201 | HS | 08.06.24 |
| A | NEW ISSUE | HS | 08.06.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | HS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | HS | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | D3773 | SHEET 1 OF 3 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | HEADREST ADAPTER | NTS |
| DATE | 08.06.24 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

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WITHOUT NOTIC
WORK ORDER
NO. 42981







D3773-1 ADAPTER

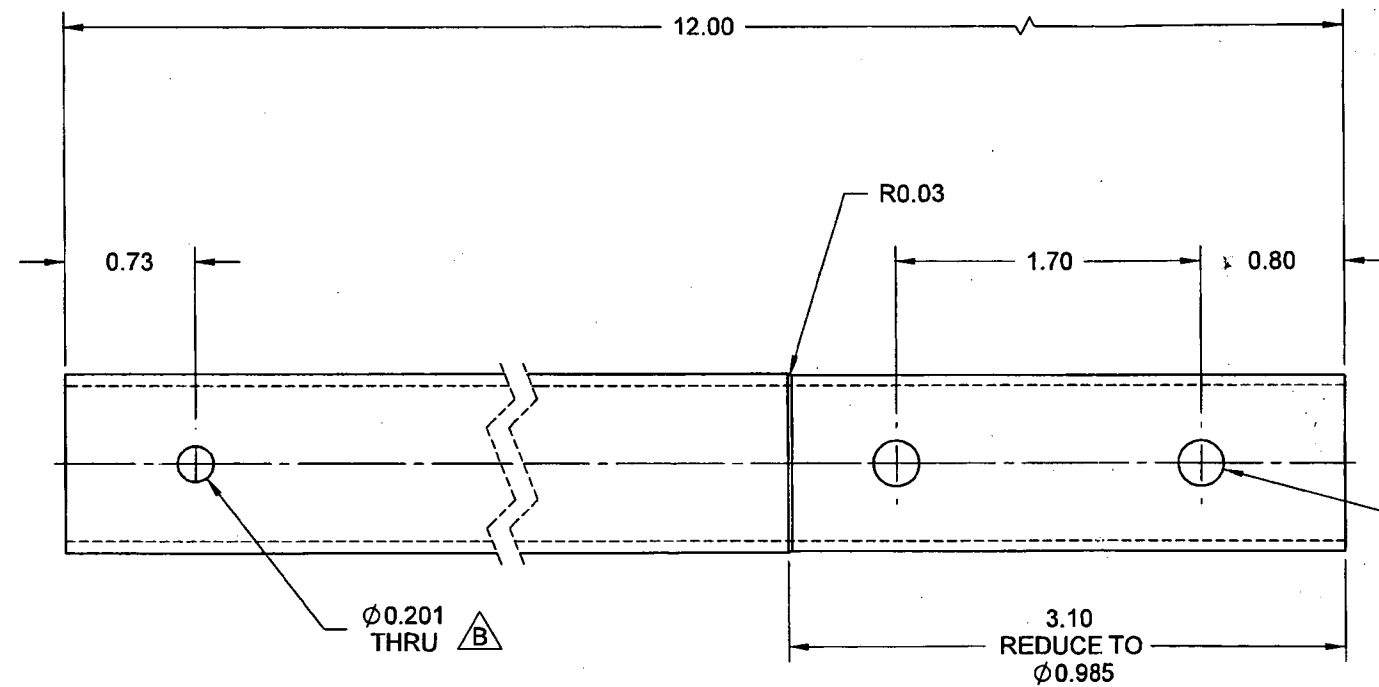
NOTES:

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.40 lbs

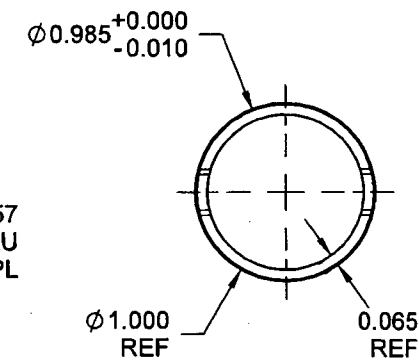
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WORK ORDER
NO. 4298

| | | |
|------------|---|--|
| DESIGN | HS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| DRAWN | HS | |
| CHECKED |  | DRAWING NO. |
| MFG. APPR. |  | D3773 |
| APPROVED |  | TITLE |
| DE APPR. |  | HEADREST ADAPTER |
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D3773-3 LEG



- NOTES:**
- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.69 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | HS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | HS | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3773 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | HEADREST ADAPTER | NTS |
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